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**27.09.95 Bulletin 95/39**(71) Applicant: **VELUWSE MACHINE INDUSTRIE  
B.V.**  
**Gelriaweg 16**  
**NL-8161 RK Epe (NL)**(72) Inventor: **de Graaf, Martin**  
**Vlekkertseveld 6**  
**NL-8166 KM Emst (NL)**(74) Representative: **De Hoop, Eric et al**  
**Octroobureau Vriesendorp & Gaade**  
**P.O. Box 266**  
**NL-2501 AW The Hague (NL)**(54) **Apparatus and method for manufacturing a green radial tyre and transfer unit for use in such an apparatus.**

(57) Apparatus and method for manufacturing a green radial pneumatic tyre. The apparatus is provided with a construction drum (2) for a tread with a belt for the radial pneumatic tyre, with a carcass drum (4) for carrying a carcass with beads and side walls for the radial pneumatic tyre and with an annular transfer unit (5) movable along a path (8) for transferring the annular tread/bead assembly to the carcass drum. The transfer unit is provided with a passage part for surrounding the drums, and with a pressure roller unit with at least one roller (9) rolling the belt/tread assembly against the carcass with the beads and the side walls. The passage part is provided with a gate (29) for radially admitting each roller (9) to the carcass with beads and side walls, the pressure roller unit being provided with means (14) for displacing each roller radially through the gate. Each gate of the passage part as seen in a direction parallel to the direction of movement of the passage part near the carcass drum is provided with a passage opening for each roll. In the method during the pressing of the tread/belt assembly onto the carcass with the beads and the side walls the transfer unit is transferred to a distance from the carcass drum.

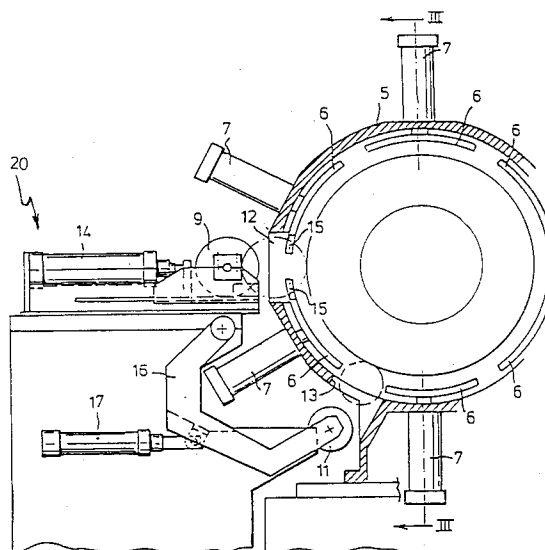


FIG. 2

**EP 0 627 302 A3**



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## EUROPEAN SEARCH REPORT

Application Number  
EP 94 20 1305

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.5)
X	PATENT ABSTRACTS OF JAPAN vol. 7 no. 63 (M-200) [1208] ,16 March 1983 & JP-A-57 208231 (YOKOHAMA GOMU K. K.) 21 December 1982,	1,5,8	B29D30/20
A	* abstract; figures 1-5 * ---	2	
Y	US-A-3 976 532 (C. K. BAREFOOT)	8	
A	* the whole document * ---	1,2,4,9	
Y	FR-A-2 289 327 (BRIDGESTONE TIRE COMP.)	8	
A	* the whole document * ---	2,3,7	
A	US-A-4 667 574 (G. FELTEN) & LU-A-86 110 (GOODYEAR TIRE & RUBBER COMP.) 24 March 1986 * the whole document * ---	1,4-7	
D,A	EP-A-0 223 317 (VMI EPE HOLLAND) * the whole document * -----	2,3	<b>TECHNICAL FIELDS SEARCHED (Int.Cl.5)</b>  B29D
The present search report has been drawn up for all claims			
Place of search <b>THE HAGUE</b>		Date of completion of the search <b>24 July 1995</b>	Examiner <b>Fregosi, A</b>
<b>CATEGORY OF CITED DOCUMENTS</b> X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document  T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ..... & : member of the same patent family, corresponding document			